

# Work Order ID 109971

\*109971\*

Page 1

December-11-13 8:29:53 AM

Item ID: D4909-1TRN

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 11/12/2013 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 17/12/2013 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

*13-12-11*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4909	A								

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FB189

DAS  
40  
9-89

13/12/11

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS  
40  
9-89

13/12/11

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

3

0

13-12-16



# Work Order ID 109971

\*109971\*

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December-11-13 8:29:53 AM

Item ID: D4909-1TRN Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Support  
 Start Date: 11/12/2013 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 17/12/2013 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				3	0		13-12-16
*130*									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MAT 060 (CNC)								
140	QC21- Final Inspection - Work Order Release	0.00							13/12/18
*140*									
QC	Memo	0.00							
Quality Control									

PLB-2-16



# Picklist Print

December-11-13 8:29:52 AM

Page 1

Work Order ID: 109971

Parent Item: D4909-1TRN

Start Date: 11/12/2013

Required Date: 17/12/2013

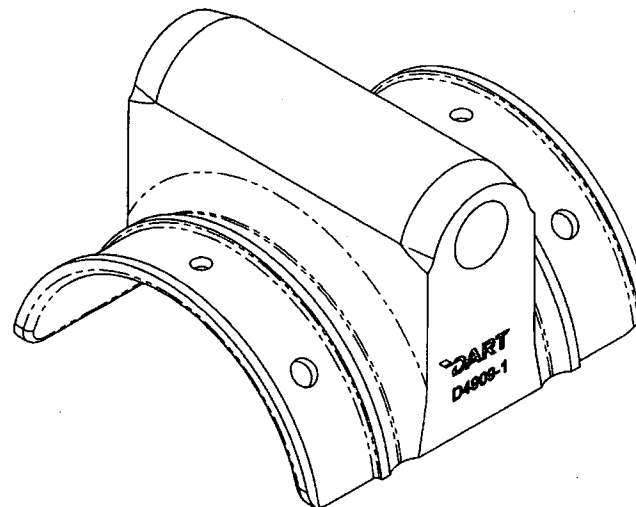
Parent Item Name: Support

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	9.0000	1	3			
17-4 SS Roundbar 6.50"OD											DAS 13/12/11		
											40		
											9-89		
						Location	Loc Qty	Loc Code					
						MAT043	9						
						106719	8		3				
						99315	1						



**D4909-1 SUPPORT**

**RELEASED**  
2013-08-06

**NOTES:**

- 1) MATERIAL: MAKE FROM D4909-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D4909-1" IN INDICATED AREA  
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,  
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.90 lbs

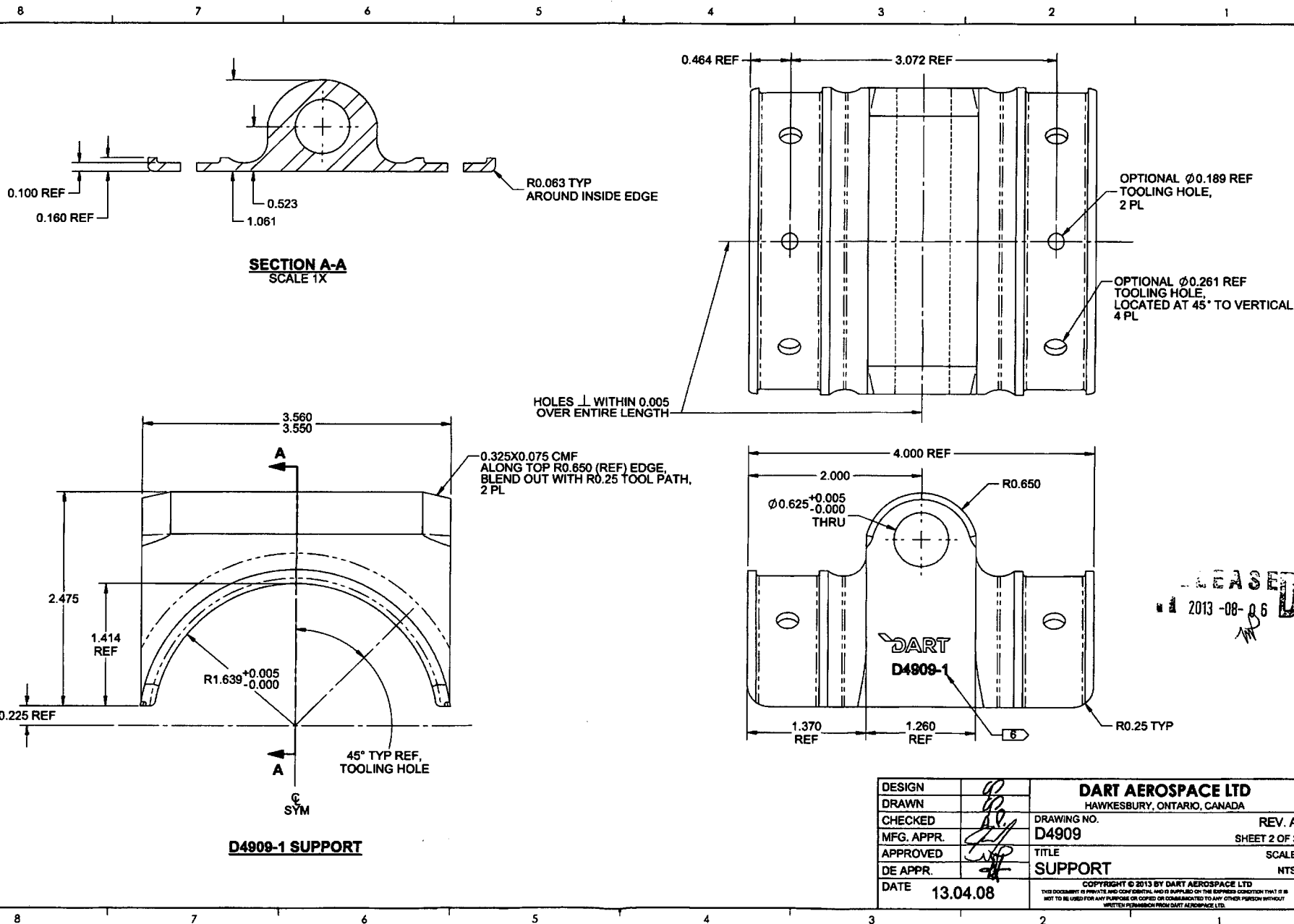
A	NEW ISSUE	CP	13.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.04.08		

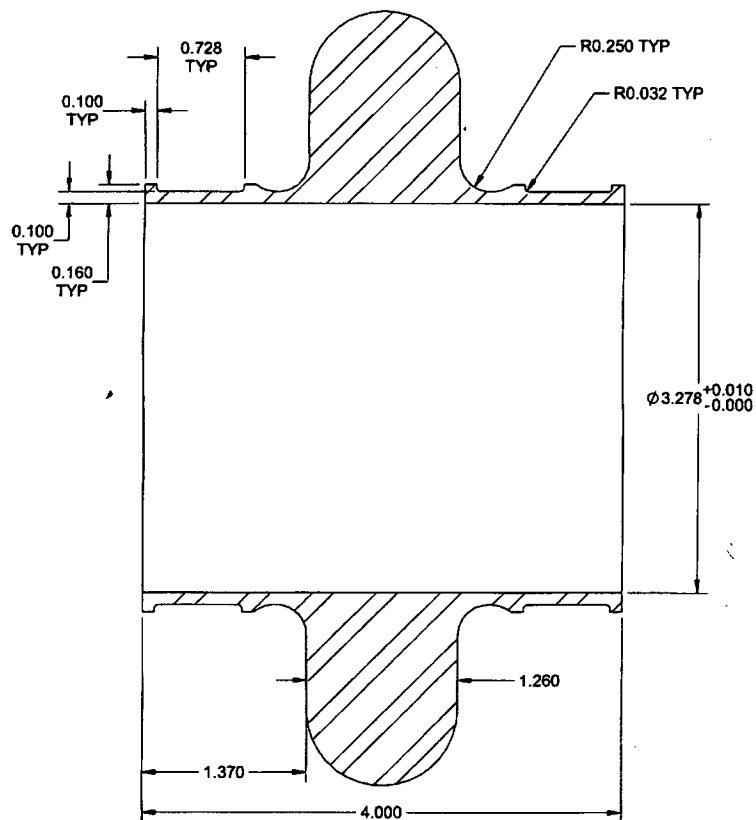
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	<b>D4909</b>	SHEET 1 OF 3
TITLE	<b>SUPPORT</b>	SCALE
		NTS

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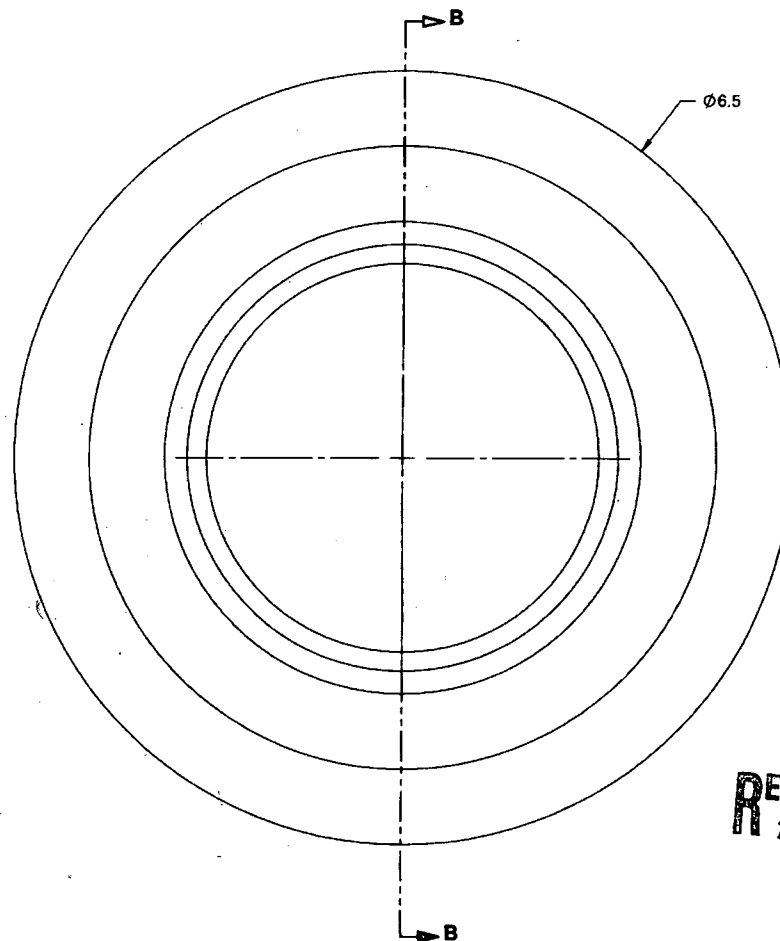
2.







**SECTION B-B**



**D4909-1TRN TURNING DETAIL**

**RELEASED**  
2013-08-06

**NOTES:**

- 1) MATERIAL: 17-4PH / S17400 / TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R  
HEAT TREAT TO H900 CONDITION (900 °F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.1 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4909</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT</b>	NTS
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DART AEROSPACE LTD		Work Order:	09971
Description: Support		Part Number:	04909-11RW
Inspection Dwg: 04909	Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>40</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: <i>13/12/11</i>	Date: <i>13-12-16</i>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



